PRODUCT DATA SHEET

Sika® Aktivator-309 P

Transparent solvent-based adhesion promoter for pinch weld and paint

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

<p>| | |</p>
<table>
<thead>
<tr>
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</thead>
<tbody>
<tr>
<td><strong>Chemical base</strong></td>
<td>Solvent-based adhesion promoter</td>
</tr>
<tr>
<td><strong>Color (CQP001-1)</strong></td>
<td>Colorless to slightly yellow</td>
</tr>
<tr>
<td><strong>Application temperature</strong></td>
<td>-10 – 40 °C (14 – 104 °F)</td>
</tr>
<tr>
<td><strong>Application method</strong></td>
<td>Single use applicator</td>
</tr>
<tr>
<td><strong>Consumption</strong></td>
<td>20 ml/m²</td>
</tr>
<tr>
<td><strong>Flash-off time</strong></td>
<td>-10 – 40 °C (14 – 104 °F)</td>
</tr>
<tr>
<td></td>
<td>maximum minimum 30 seconds 15 minutes</td>
</tr>
<tr>
<td><strong>Shelf life (CQP016-1)</strong></td>
<td>9 months A</td>
</tr>
</tbody>
</table>

CQP = Corporate Quality Procedure

A) stored in sealed container in a dry place at ≤ 25 °C

DESCRIPTION

Sika® Aktivator-309 P is an solvent-based colorless adhesion promoter which reacts with moisture and deposits active groups on the substrate. These groups act as a link between substrates and primers or sealants/adhesives. Sika® Aktivator-309 P is specifically formulated for the treatment of pinchweld substrates like paint, cut polyurethane, etc. prior to application of Sika’s polyurethane adhesives.

PRODUCT BENEFITS

- Improves adhesion to body side substrates
- Shortest flash-off time
- Easy to apply
- Transparent

AREAS OF APPLICATION

Sika® Aktivator-309 P improves adhesion on body side substrates such as paint, pre applied adhesive systems, encapsulation on wind-screens and cut face of old polyurethane adhesive.

It must not be used on glass or ceramic frits!

This product is suitable for experienced professional users only. For other applications than Automotive Glass Replacement, tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.
METHOD OF APPLICATION
Surfaces must be clean, dry and free from grease, oil, dust and contaminants. Adhesion on substrates may be improved by adding and/or combining pre-treatment processes such as scuffing and cleaning prior the activator application.

Application
Point felt tip toward the ground and pinch the handle with thumb and index finger to break internal vial thus releasing Sika® Aktivator-309 P into the felt tip (do not bend!). Apply the Sika® Aktivator-309 P to the pinch-weld in one direction while maintaining continuous contact, making sure to cover all areas of trimmed urethane. Finish just beyond the beginning point to ensure complete coverage of bond area.

Sika® Aktivator-309 P has to be applied sparingly (ensuring the bond face has been treated) as excess of activator could lead to adhesion failure.

If the pre-treated area is not bonded within the maximum flash-off time, the activation process has to be repeated (once only).

Ideal application and surface temperature is between 15 °C and 25 °C.

IMPORTANT NOTE
Sika® Aktivator-309 P contains solvent which may dull the surface finish of some freshly applied paints. Preliminary trials must be carried out. Never apply to porous substrates since it may not dry completely and prevent the adhesive or sealant from curing. Protect adjacent surfaces by masking where necessary. Never dilute or mix Sika® Aktivator-309 P with any other substances. It must not be used for tooling/smoothing of products or as cleaning agent.

LEGAL DISCLAIMER
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